






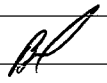


# Work Order ID 53446






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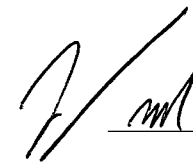
Item ID: D3413-1 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Ring  
Start Date: 05/11/2009 Start Qty: 20.00  Cust Item ID:  
Required Date: 26/11/2009 Req'd Qty: 20.00  Customer:  
Reference:

Approvals: Process Plan:  Date: 09-11-5 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
Run Start   
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3413	Rev A								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3413								
	Dwg Rev: 								
	Prog Rev: 								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

09-11-10

09-11-10

 09 11 10 (30)

# Work Order ID 53446

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Item ID: D3413-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Ring

Start Date: 05/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 26/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

*Handwritten signature* 09/11/11 (30)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*Handwritten signature* 09/11/12

30

155



Spray Painting per QSI005 4.2

0.00

SprayPaint

Memo

0.00

Spray Painting

*Handwritten signature* 09 11 24

Primer B 110918  
Defect Blue B 113171  
Clear B 113088

# Work Order ID 53446

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Item ID: D3413-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Ring

Start Date: 05/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 26/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

RT 09-11-26 (K24)

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/11/30 (Box) sl

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/30 (30)

# Picklist Print

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Work Order ID: 53446



Parent Item: D3413-1RevA



Parent Item Name: Ring

Start Date: 05/11/2009

Required Date: 26/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	25.4166	5.2632	8.		
304 BAR-250 x 4.00												

B 9-11-10

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

25.4166

105358

1.4166

113084

24

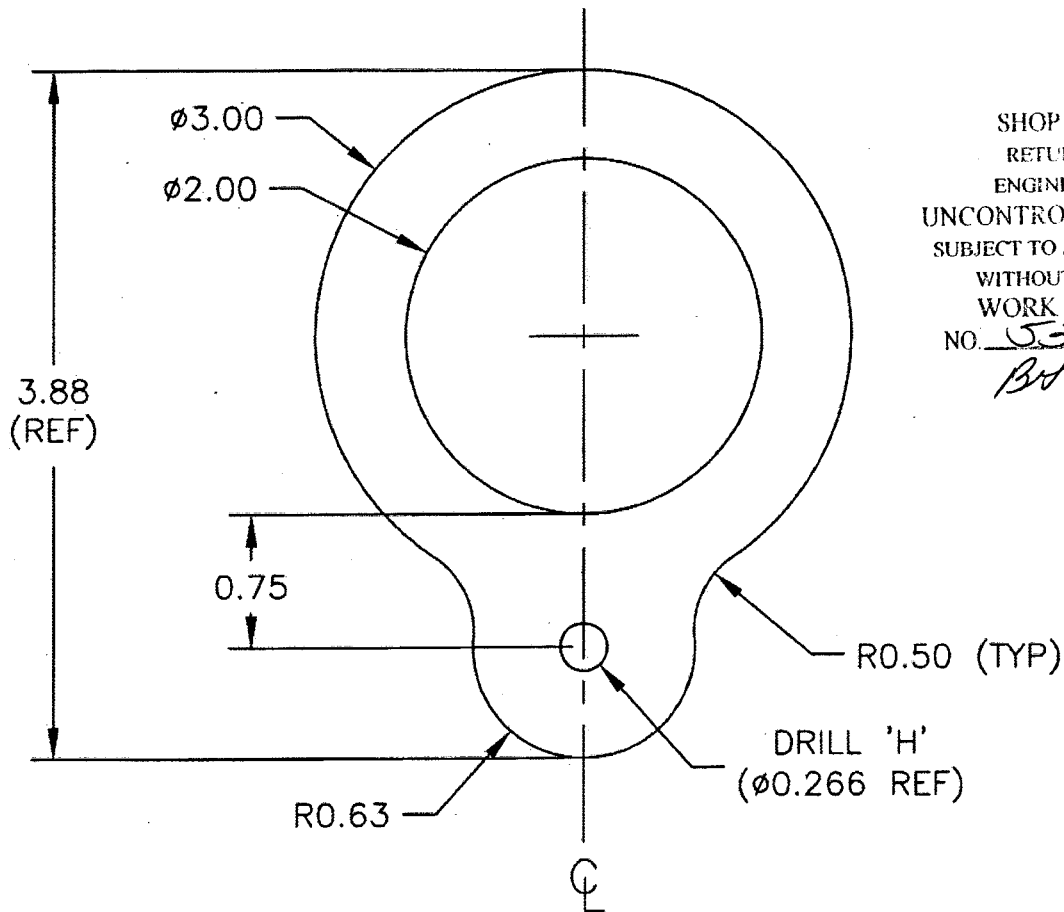
113084

(30)



**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

**RELEASED**  
05-09-06 *[Signature]*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 534146  
*BD 09-11-5*

**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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